



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5762-2

Job Sheet 207377



POSITIVE
RECALL

Part No: D5762-2

Job Qty: 10 pcs

Part Name: Beam, RH



Part Weight: 0 lbs

Status: New

Job Created: 2/25/20

Job Tracking No:

Due Date: 3/6/20

Created By: Jennifer Renwick

Type: Stock

Description:

Priority: Medium

Note: URF 2020-525 Was PN: 78633-02 DWG D5762 REV:A IPP REV:A 2020.01.09 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	3/6/20		1.00	5.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	QC 2	10 pcs	3/6/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S266449



Part: D5762-2

Job No: 207377

Serial No/Batch: S266449

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/25/20

Plex 2/25/20 12:03 PM DartLajeunesse.marc

120 QC 8	10 pcs	3/6/20	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
130 Packaging 3-1 - Stock - B4B	10 pcs	3/6/20	0.00 0.00	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	

WHS 20/3/27

DAS
28
9-88

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	10 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

CCK095

MAR 3 0 2020

Part Op 100 - ***Machine all holes and top slots*** 1-Machine as per folio FD153 FOLIO REV: AA DWG REV: A
 Descriptions: A 2-Debur
 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Identify as per D5762-2 dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TS2.000X1.000W.065	Rectangle tubing, 2.000 X 1.000" x 0.065 Wall	20.9580 ft (2.0958 ea)	100-HAAS 4 Axis	<u>5263537</u>

Job Allocations

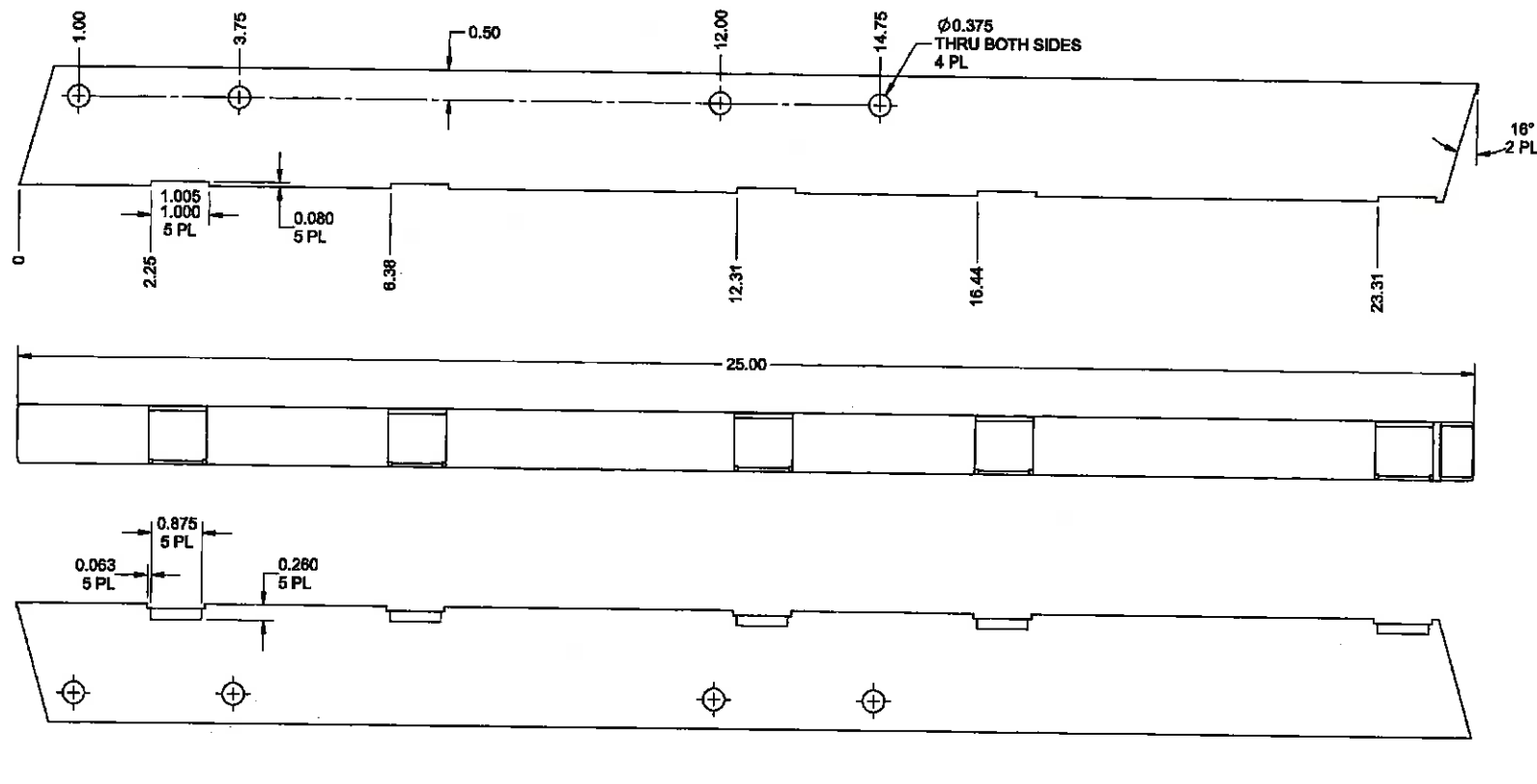
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	M304TS2.000X1.000W.065	21	0	0

Part Specifications

Specifications could not be found.

Plex 2/25/20 12:33 PM Dart.lajeunesse.marie

8 7 6 5 4 3 2 1



D5762-2 BEAM, RH
(DERIVED FROM AERO DESIGN P/N 78633-02)

UNDER REVIEW
URF 2020-524 20.02.20 (NO)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 202377 ML5
20-02-25
2020 FEB 19

- NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBING, 2.00 X 1.00 X 0.065 WALL
PER ASTM A554 OR ASTM A269
REF DART SPEC M304TS
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 2.41 lbs

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	NO	DRAWING NO.	REV. A
MFG. APPR.	DD	D5762	SHEET 8 OF 14
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	AFT BEAM	NTS
DATE	19.12.17	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE BUYER'S EQUIPMENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		FAULT CATEGORY <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
		Other/Details:			

DART AEROSPACE LTD		Work Order:	207377
Description: AIT Beam		Part Number:	D5762-2
Inspection Dwg: D5762	Rev: A		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	<i>AE</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	<i>20/03/25</i>	Date:	<i>20/3/27</i>	Date:	

Engineering Approval: (If necessary)		Date:
--	--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045970



Supplier: ACI001-VC
Acier Quellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5896

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045970

PO Date: 2/27/20

Due Date: 3/13/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: quote no. SOU0243320

E-MAILED
MAR 02 2020

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M17-4-B1.250X2.000			17-4 SS Bar 1.250 x 2.00 MATERIAL: 17-4 PH SS BAR AS PER AMS 5804/5843 GRAIN MUST BE ALONG LENGTH OF BAR MIN. YIELD TENSILE STRENGTH = 100 KSI MIN. ULTIMATE TENSILE STRENGTH = 150 KSI receive ft	Firmed -		3/13/20	12 ft	0 ft	12 ft	\$95.08333/R	\$1,141.00
2		M304B0.375X03.000			M304 SS bar .375 x 3.00 MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed -		3/5/20	12 ft	0 ft	12 ft	\$11.335/R	\$136.02
3		M304B0.188X0.188			304 Bar, 0.188 X 0.188	Firmed -		3/5/20	12 ft	0 ft	12 ft	\$1.29/R	\$15.48



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K8A 1K7
Canada

Tel (813) 632-5200

PURCHASE ORDER POHB045970



Items													
Line item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4		M304B0.625X3.000			304 BAR 0.625" X 3.000" : MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed -		3/13/20	12 ft	0 ft	12 ft	\$27 175833/ft	\$326.11
5		M304S16GA	D3494		304/316 Sheet 065 : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed -		3/13/20	192 sf	0 sf	192 sf	\$6.4020312/sf	\$1,229.19
6		M304S18GA			304/316 050 Sheet : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed -		3/13/20	192 sf	0 sf	192 sf	\$5.3732812/sf	\$1,031.67
7		M304TS2.000X1.000W.065			Rectangle tubing. 2.000 X 1.000" x 0.065 Wall : MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A564 MILL FINISH OR ASTM A269 MILL FINISH	Firmed -		3/13/20	60 ft	0 ft	60 ft	\$4.25/ft	\$255.00



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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER POHB045970



Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8		M304TS2 000X1 000W 125			Rectangle Tubing, 2.000 X 1 000 X 0 125 Wall. MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING-AS PER <u>ASTM A554</u> MILL FINISH OR ASTM A269 MILL FINISH	Firmed -		3/13/20	20 ft	0 ft	20 ft	\$7.0995/ft	\$141.99
9		M304R1.000			304 Round Bar 1.00 MATERIAL: AISI 304/316 SS ROUND BAR AS PER <u>ASTM A276</u> NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed -		3/13/20	24 ft	0 ft	24 ft	\$8.168/5ft	\$196.05
10		M303B1 000X3.000			303 Bar 1" X 3" MATERIAL: AISI 303 SS BAR AS PER <u>ASTM A582</u> NOTE: AISI 304/316 NOT ACCEPTABLE receive ft	Firmed -		3/17/20	12 ft	0 ft	12 ft	\$117.875/ft	\$1,414.50
11		M303H1.500			303 Hex Bar .500 MATERIAL: AISI 303 SS HEX BAR AS PER <u>ASTM A582</u> NOTE: AISI 304/316 NOT ACCEPTABLE receive ft	Firmed -		3/13/20	12 ft	0 ft	12 ft	\$6.1308333/ft	\$73.57
Grand Total:												\$5,960.58	

Order Notes

Procurement Quality Clauses

- A005 right of entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)
- A026 certification of material conformance
- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.plexonline.com/6642717d-a3fd-4372-98bf-a596f6258f7b/Plexus_Control/Report_View_2.asp?rv=u%1E-%2FPurchasing%2FPO_Print.a.. for further explanation.

Plex 3/2/20 9 21 AM Dart Layole, Chantal

**ACIER QUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél : 450-377-4248 MH: 514-336-4248 Ext : 800-667-4248
Fax: 450-377-5696 MH: 514-336-4246 Ext. 866-456-4242

DELIVERY - CLIENT

CO00194479

Billed to

DART AEROSPACE LTD

1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att : CHANTAL LAVOIE Tél.: 613-632-5200

Instruction F-M**Delivery Route** 5**Customer N°**

CLI0001056

Date

2020/03/02

Delivery date**2020/03/13****Your order R°**

POHB045970

Processed by

Josianne Bourdon

Salesman

JOSIANNE BOURDON

Carrier

QUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Product Description	Weight	Qty	UN	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	CUT
1 PLATE SS 1 1/4 17-4 PI: NS PSS-114174 10061 1 X 2" X 12' R/L POHB045970 LINE 1 HEAT: 92103404 AC34489-JO-11/03	106.45	2.00	PI2_\$CLB		1X 139						
2 FLAT SS304 3/8 X 3 (R) FSS-383 3578 1 X 12' R/L POHB045970 LINE 2 HEAT: 1012679	45.96	12.00	PL_\$CLB		1X12'						
3 SQUARE SS 3/16 SS304 CSS-316 8678 1 X 12' R/L POHB045970 LINE 3 HEAT: 38820	1.44	12.00	PL_\$CLB		1X12'1"						
4 FLAT SS304 5/8 X 3 FSS-583 9221 1 X 12' R/L POHB045970 LINE 4 HEAT: 54035	76.56	12.00	PL_\$CLB		1X12'4"						
5 SHEET SS 16G SS304-2D (4 X 8) DART FESSD-16G4830428 12463 6 X 4' X 8' POHB045970 LINE 5	504.00	192.00	PI2_\$CLB		6X4'8"						

RECEIVED

MAR 13 2020

DART AEROSPACE LTD.

Product Description	Qty	Weight	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
HEAT: 55859 PACKAGING 6 SHEET SS 18G SS304-2B (4 X 8) FESS-18G483042B 3425 6 X 4' X 8' POHB045970 LINE 6 HEAT: 856818 PACKAGING	403.20	192.00	UN PI2_\$CLB								
7 TUBE SS 304 180G 2 X 1 X .065 (R) TSS-21065 7115 3 X 20' R/L POHB045970 LINE 7 HEAT: ACH040567 TRANSFERT ST-JEROME LE 04/03	76.20	60.00	UN PI_\$CPI								
8 TUBE SS 304 180G 2 X 1 X .120 (R) TSS-21120 7117 1 X 20' R/L POHB045970 LINE 8 HEAT: TRK113045 AC34490-SM-11/03	45.04	20.00	UN_\$UN PI_\$CPI								
9 ROUND SS 304 1 (R) RSS-1 5747 2 X 12' R/L POHB045970 LINE 9 HEAT: 19L0767	64.08	24.00	UN_\$UN PI_\$CLB								
10 FLAT SS303 1 X 3 FSS-13303 9735 1 X 12' R/L POHB045970 LINE 10 HEAT: 280130	123.00	12.00	PI_\$CLB								
11 HEXAGONE SS 1/2 SS303 XSS-12303-V 8748 1 X 12' R/L POHB045970 LINE 11 HEAT: E150111	8.83	12.00	PI_\$CLB								

3 / 3

7115 TSS-21065

7115 AC 325A-1
TRA-7608
2048

Certificate No.	F190518005
Date:	JUN 06, 2019

檢驗證明書 MILL'S TEST CERTIFICATE



財源企業股份有限公司
FROCH ENTERPRISE CO., LTD.

NO.122 INDUSTRIAL ROAD, TOU-LIU CITY

YUN-LIN 840, TAIWAN

TEL: +886-5-5571689

FAX: +886-5-5571339

Website: www.froch.com

ORIGINAL

Invoice No.		Contract No.		L/C No.		Specification		Page: 1 of 2														
FEX20190782		MN6528		T/T		ASTM A564-2016																
Description		Spec No.	Size	Type	Heat No.	QTY(FT)	Weight(Kg)	Heat Treatment Water Quenched	Finish	Hydrostatic Test (MPa)	Remark											
STAINLESS STEEL WELDED TUBE ASTM A564-2016, MT304, ROUND TUBE: 180G POLISHED, SQUARE AND RECTANGULAR TUBE: MT180G POLISHED, CUT IN THE LENGTH OF 20 FT		9	1" X .048" 180G	MT 304	AOH040623	1,880.000	---	---	180G	---												
		10	1" X .120" 180G	MT 304	AOH050039	9,940.000	---	---	180G	---												
		11	1-1/2" X .120" 180G	MT 304	AOH050199	5,000.000	---	---	180G	---												
		12	1" X 1-1/2" X .065" 180G	MT 304	ALK040579	580.000	---	---	180G	---												
		13	1" X 1-1/2" X .065" 180G	MT 304	ALB040579	60.000	---	---	180G	---												
		14	1" X 2" X .065" 180G	MT 304	AOH040562	2,600.000	---	---	180G	---												
		15	3/4" X 3/4" X .065" 180G	MT 304	ALB040072	1,880.000	---	---	180G	---												
		16	1" X 1" X .120" 180G	MT 304	ALB050058	240.000	---	---	180G	---												
		17	1" X 1" X .120" 180G	MT 304	ALB050206	740.000	---	---	180G	---												
		18	1" X 1" X .120" 180G	MT 304	AOH040198	2,320.000	---	---	180G	---												
		Chemical Composition (%)																				
		Item No.	C	Si	Mn	P	S	Cr	Ni	Mo	N	Other	Tensile (N/mm ²)	0.2% Yield (N/mm ²)	Elongation (%)	Direction	Width of specimen (mm)	Gauge Length (mm)	Hardness HRB	Flattening Test	Band Test	Ring Test
		Max.	0.080	1.000	2.00	0.045	0.030	18.00	8.00	---	---	---	615.00	205.00	40.00	LT	mm	mm	---	---	---	---
		9	0.046	0.420	1.06	0.033	0.005	18.37	8.05	---	---	---	636.04	286.16	58.80	---	---	---	83.80	No Crack	No Crack	No Crack
		10	0.022	0.390	1.50	0.028	0.001	18.19	8.00	---	---	---	694.00	270.00	52.00	---	---	---	83.50	---	---	---
		11	0.022	0.390	1.50	0.028	0.002	18.10	8.00	---	---	---	659.00	269.00	52.00	---	---	---	81.50	---	---	---
		12	0.054	0.490	1.06	0.033	0.002	18.29	8.07	---	---	---	626.16	287.14	56.70	---	---	---	83.70	---	---	---
		13	0.022	0.400	1.07	0.028	0.004	18.31	8.01	---	---	---	684.00	306.00	50.00	---	---	---	87.00	---	---	---
14	0.048	0.420	1.07	0.034	0.004	18.40	8.02	---	---	---	636.02	292.04	56.60	---	---	---	83.70	---	---	---		
15	0.034	0.520	1.11	0.034	0.007	18.22	8.32	---	---	---	632.00	297.00	56.70	---	---	---	80.40	---	---	---		
16	0.018	0.420	1.41	0.036	0.003	18.17	8.03	---	---	---	659.00	320.00	60.00	---	---	---	88.00	---	---	---		
17	0.014	0.410	1.69	0.028	0.002	18.10	8.00	---	---	---	604.00	271.00	56.10	---	---	---	82.40	---	---	---		
18	0.015	0.370	1.86	0.027	0.002	18.30	8.00	---	---	---	654.00	275.00	54.00	---	---	---	82.00	---	---	---		

NOTES:

- The material described herein is certified for no radiation contamination by original Material Manufacturer.
- Chemical composition and result of machinery test are from origin end only for reference.
- The tolerance of chemical composition is according to ASTM A480.
- Visual Inspection(Surface) and Dimension Check: Acceptable.
- We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

MATERIAL IS MANUFACTURED MERCURY FREE
MATERIAL IS FREE FROM MERCURY CONTAMINATION.
Froch Enterprise does not add any Mercury during the pipe rolling process.

APPROVED CERTIFICATE

- QMS according ISO 9001(TUV Cert No.01 100 125922)
- EMS according ISO 14001(LR Cert No.0992007)
- FED (TUV Cert No. 01 202 TWRQ-06 0145)
- Lab management system according ISO/IEC 17020(TAF Cert No.30001)
- Lab management system according ISO/IEC 17025(TAF Cert No.2371)

Lin Yu Lin
 QA Manager / Work Inspector.

Heat: AOH 040562

Q-Y-Q-33-02-E

LINE 7

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304TS 2.000X1.000 W. 065 PO / BATCH NO.: P0113045970
 DATE: MAR 17 2020 5263537

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 60 FT
 QUANTITY INSPECTED: 60 FT
 QUANTITY REJECTED: —

THICKNESS ORDERED: 2.000X1.000 W. 065
 THICKNESS RECEIVED: 2.000X1.000 W. 065
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	Y (N)	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	Y (N)	
CORRECT MATERIAL PER H-DRAWING	Y (N)	ASTM A554
CORRECT THICKNESS	Y (N)	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	Y (N)	HIT ACH 040562
CORRECT MATERIAL IDENTIFICATION	Y (N)	
CORRECT M# ON THE MATERIAL	Y (N)	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

Testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>MAR 17 2020</u>	<u>82</u>	SIGNED OFF BY: <u>—</u>	
DATE: <u>3 17 2020</u>	<u>9-89</u>	DATE: <u>—</u>	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in


LINE 7
M304TS 2.000 X 1.000 W.065

DAS
82
9-89



PURCHASE MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE/RECTANGULAR TUBING 

FINISH:  ASTM A269 MILL FINISH
OR ASTM A269 MILL FINISH

PART NUMBER: M304TS A AAA X B.BBB W TTT
WIDTH HEIGHT WALL

PART NUMBER: EG. (SQUARE TUBE) 0.75" X 0.75" X 0.049 WALL = M304TS0.750W.049
EG. (RECTANGULAR TUBE) 2.00" X 1.00" X 0.065 WALL = M304TS2.000X1.000W.065 

WHERE: A AAA = WIDTH IN INCHES
R BBB = HEIGHT IN INCHES (OPTIONAL, OMIT FOR SQUARE TUBE) 
TTT = WALL THICKNESS IN INCHES

E	ADDED OPTION FOR RECTANGULAR TUBING (OPTIONAL HEIGHT IN PART NUMBER). REMOVED "SQUARE" FROM TITLE AND PURCHASE MATERIAL.	ZF	19.12.17
D	"SEAMLESS" REMOVED FROM PURCHASE MATERIAL SPECIFICATION (SEE NCR14-3818).	DB	14.08.20
C	"SEAMLESS" ADDED TO PURCHASE MATERIAL. ASTM A269 ADDED TO FINISH REASON SPEC ADDED FOR 1/2" TUBING.	AJS	09.10.16
B	DRAWING MOVED TO "B" SIZE BORDER, FINISH ADDED (SEE NCR 08-045 FOR DETAILS).	AJS	08.09.20
A	NEW ISSUE	DS	01.05.09
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA DRAWING NO. M304TS SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO CONFIDENTIAL INFORMATION. IT IS NOT TO BE RELEASED FOR ANY PURPOSES OR TO ANY PERSONS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DRAWN	ZF		
CHECKED	KPT		
MFG APPR	DD		
APPROVED	NO		
DE APPR	CP 	304/316 TUBING 	
DATE	19.12.17		

RELEASED

2020 FEB 18
EON 2-20-52

APPROVED